

# Work Order ID 62603

October 5, 2010 8:21:45 AM

Page 1

Item ID: D3650-041

Accept

Revision ID:

Item Name: Tunnel Top Panel Assembly

Start Date: 10/05/10 Start Qty: 2.00

Required Date: 10/15/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3650

Rev C

100

Pick Kit

0.00

SS 11/01/13

(2)

Packaging

Memo

0.00

Packaging

110

0.00

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D3650; 2- Seal all mating surfaces and all gaps using  
Proseal 700 fire wall sealant; as per dwg D3650; Batch: M 116573

ES 11/01/13

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sub 13

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62603**

October 5, 2010 8:21:46 AM



Page 2

Item ID: D3650-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tunnel Top Panel Assembly

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

B 62596

0.00

SB 11/01/13

②

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/13

ME

11-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October 5, 2010 8:21:44 AM

Page 1

Work Order ID: 62603

Parent Item: D3650-041

Parent Item Name: Tunnel Top Panel Assembly

Start Date: 10/05/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-11-12 EC verified by: DD  
IPP Rev:B Ecn 1113P 08-01-22 DD verified by:EC  
IPP Rev:C Ecn 1162 08-04-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A		Purchased	No			110	Each	227.0000	8	8	SB	11/01/13	



Bolt

Location

Loc Qty

Loc Code

ST350

227

111916

2

115159

200

115371

25

AN960C10

NAS1149C0363  
R

Purchased

No

100

Each

0.0000

8

8



WASHER

D3650-1

Manufactured

No

110

Each

0.0000

1

1



Aft Panel

D3650-3

Manufactured

No

110

Each

8.0000

1

1



Center Panel

Location

Loc Qty

Loc Code

ST189

8

53842

8

SB 11/01/13

SB 11/01/13

SB 11/01/13

~~M 113889~~



16

M 113889



B 61743



2

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October 5, 2010 8:21:44 AM

Page 2

Work Order ID: 62603

Parent Item: D3650-041

Parent Item Name: Tunnel Top Panel Assembly

Start Date: 10/05/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

D3650-5

Manufactured

No

110

Each

2.0000

1

1



SB 11/01/13

Fwd Panel

Location

Loc Qty

Loc Code

ST189

2

47872

2

2

October 5, 2010 8:21:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

5

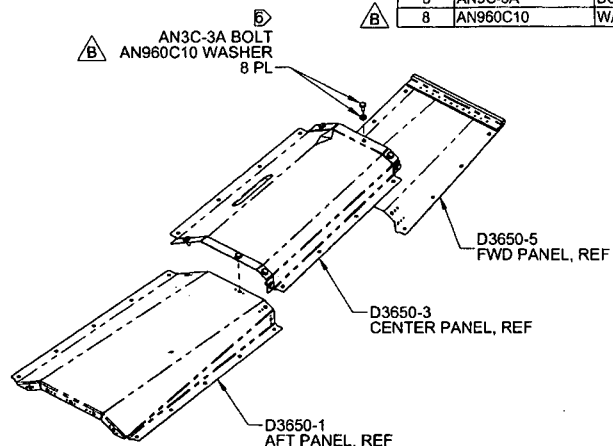
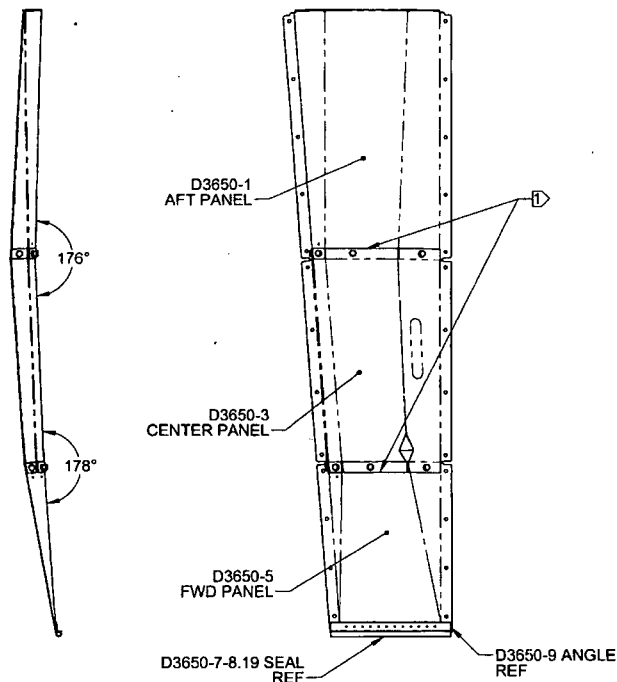
4

3

2

1

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



DEO ATTACHED

UNDER REVIEW

OK  
07.07.05  
PAR 07.06.21RELEASE  
07.11.17**D3650-041 TUNNEL TOP PANEL ASSEMBLY****NOTES:**

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

wlb 62603

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW I-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6); MS20615-4M5 WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7; B5-7; B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11F FROM SHEET 6; UPDATED DIMS OF D3650-11F-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	08.10.14		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3650</b> REV. C SHEET 1 OF 9 TITLE <b>TOP PANEL ASSEMBLY</b> SCALE 1:8 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

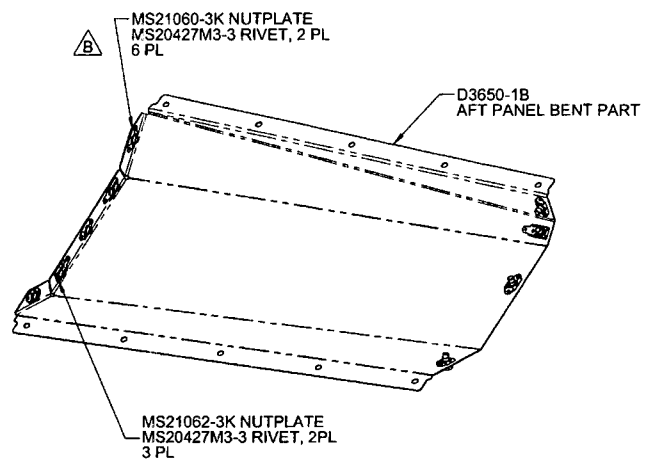
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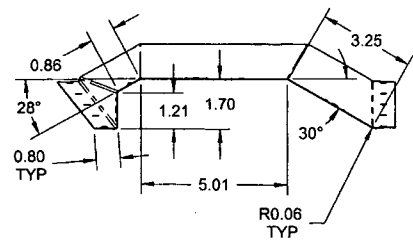
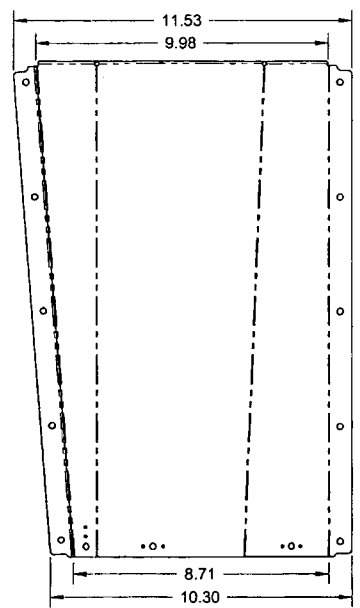
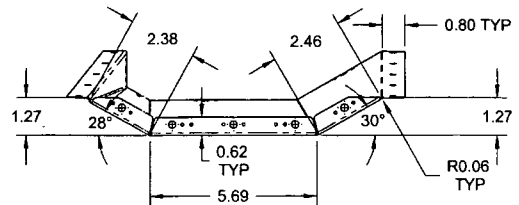
C

B

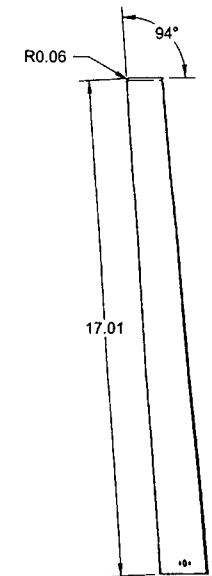
A



**D3650-1 AFT PANEL**



QTY	PART NUMBER	DESCRIPTION
-1	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE



DEO ATTACHED

UNDER REVIEW

RELEASED

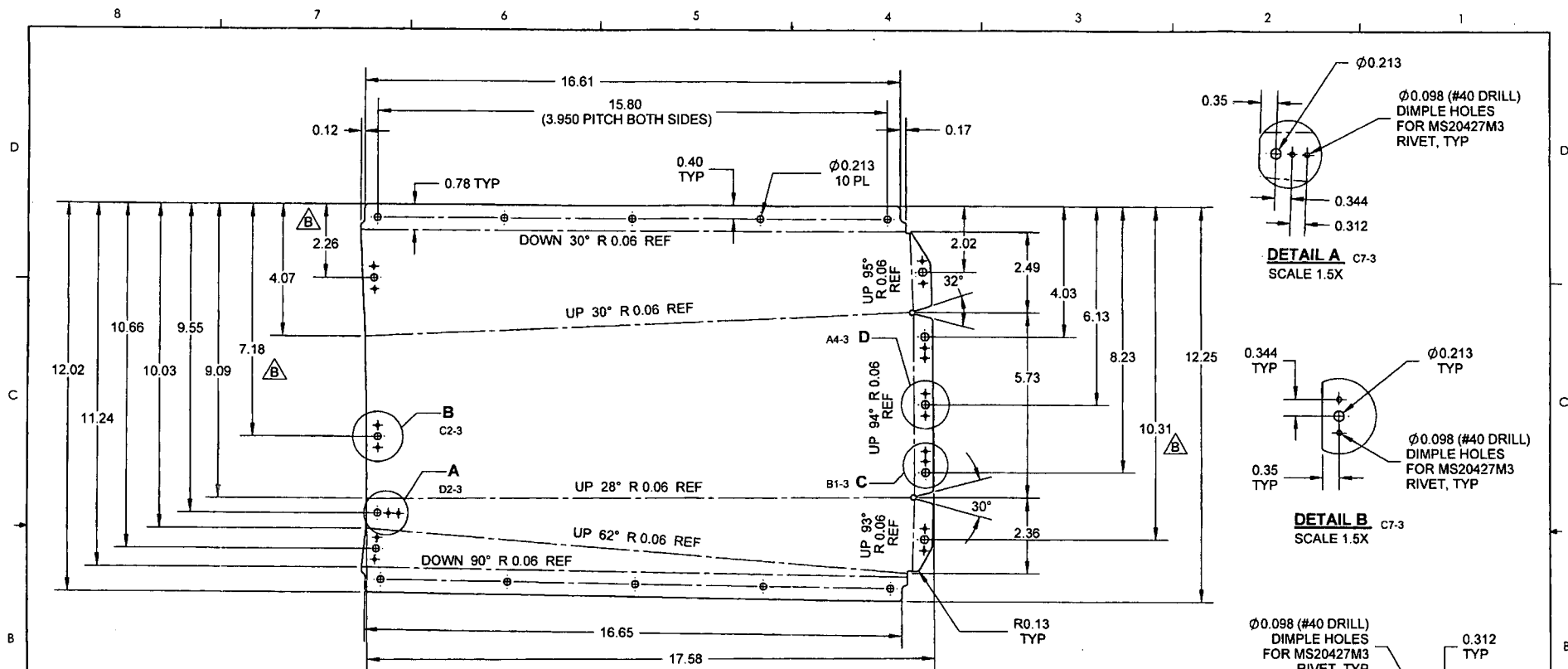
**D3650-1B AFT PANEL BENT PART**  
(MAKE FROM D3650-1F FLAT PATTERN)

- NOTES:
- 1) FINISH: NONE
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: NONE
  - 6) WEIGHT: 1.3 lbs

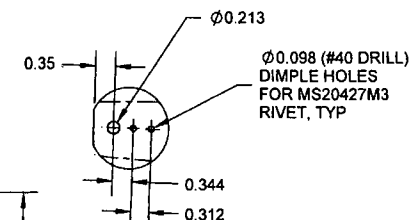
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
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62603

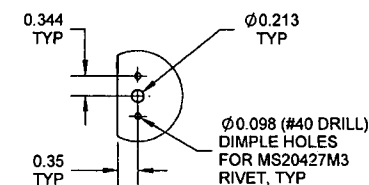
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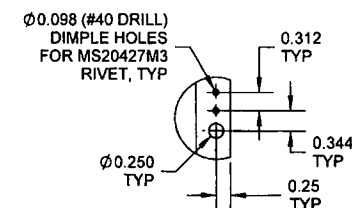
# **D3650-1F FLAT PATTERN**



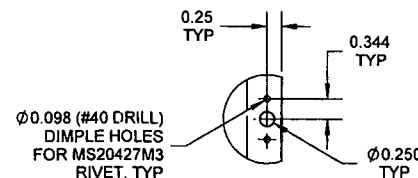
**DETAIL A** C7-3  
SCALE 1.5X



**DETAIL B** C7-3  
SCALE 1.5X



**DETAIL C** C4-3  
SCALE 1.5X



**DETAIL D** C4-3  
SCALE 1.5X

## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.22 lbs

**UNDER REVIEW**

*Handwritten signature and date: 08.10.14*

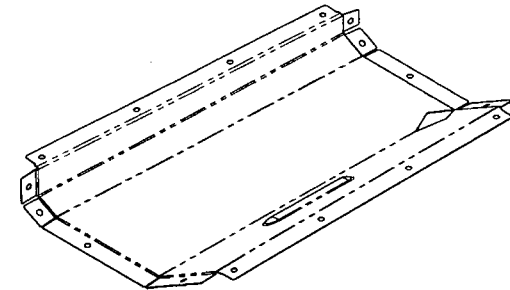
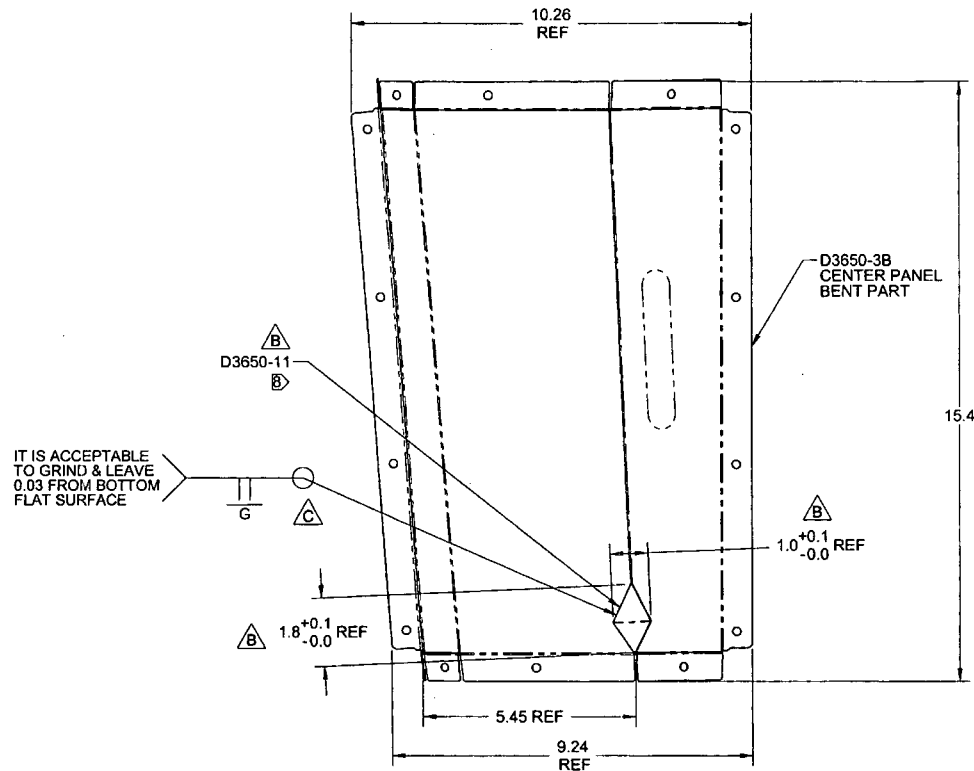
**DEO ATTACHED**

**RELEASED**  
*Handwritten date: 08/11/14*

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>Handwritten signature</i>	DRAWING NO. <b>D3650</b>	REV. C
MFG. APPR.	<i>Handwritten signature</i>	SHEET 3 OF 9	
APPROVED	<i>Handwritten signature</i>	TITLE	SCALE
DE APPR.	<i>Handwritten signature</i>	<b>TOP PANEL ASSEMBLY</b>	NTS
DATE	<b>08.10.14</b>	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

*Handwritten number: 62603*

QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE



**D3650-3 CENTER PANEL**  
(LOOKING FROM OUT SIDE SURFACE)

DEO ATTACHED

**RELEASED**  
08/11/14

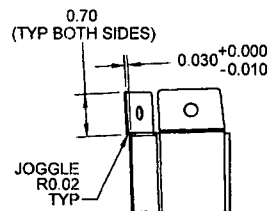
- NOTES:**
- 1) WELD PER QSI 004
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.0 lb
  - 8) TRIM D3650-11 TO FIT AS REQUIRED

**UNDER REVIEW**

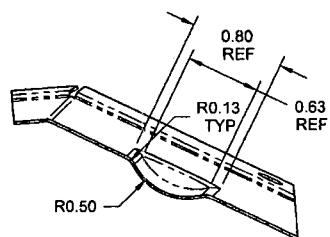
08/10/14  
08/10/14

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3650</b>	REV. C
MFG. APPR.			SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>TOP PANEL ASSEMBLY</b>	NTS
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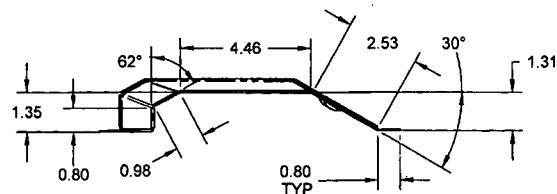
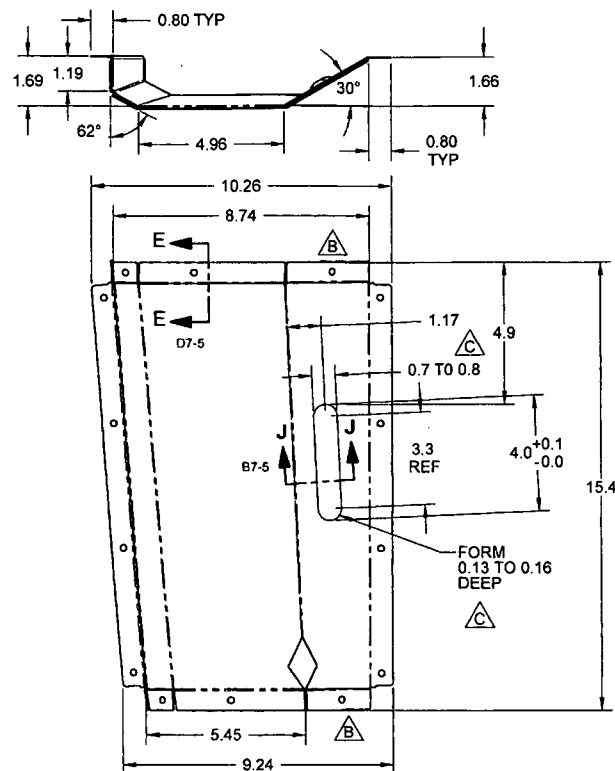
62603



**SECTION E-E** D5-5  
SCALE 2X



**SECTION J-J** C5-5  
SCALE 3.5X

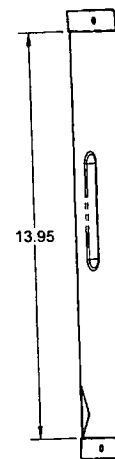
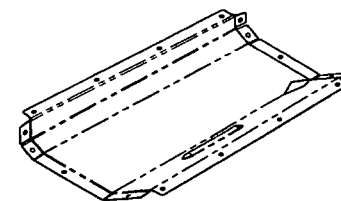


**D3650-3B CENTER PANEL BENT PART**  
(MAKE FROM D3650-3F FLAT PATTERN)

- NOTES:**  
 1) FINISH: NONE  
 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 3) UNITS: INCHES UNLESS OTHERWISE NOTED  
 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 5) IDENTIFICATION: NONE

**UNDER REVIEW**

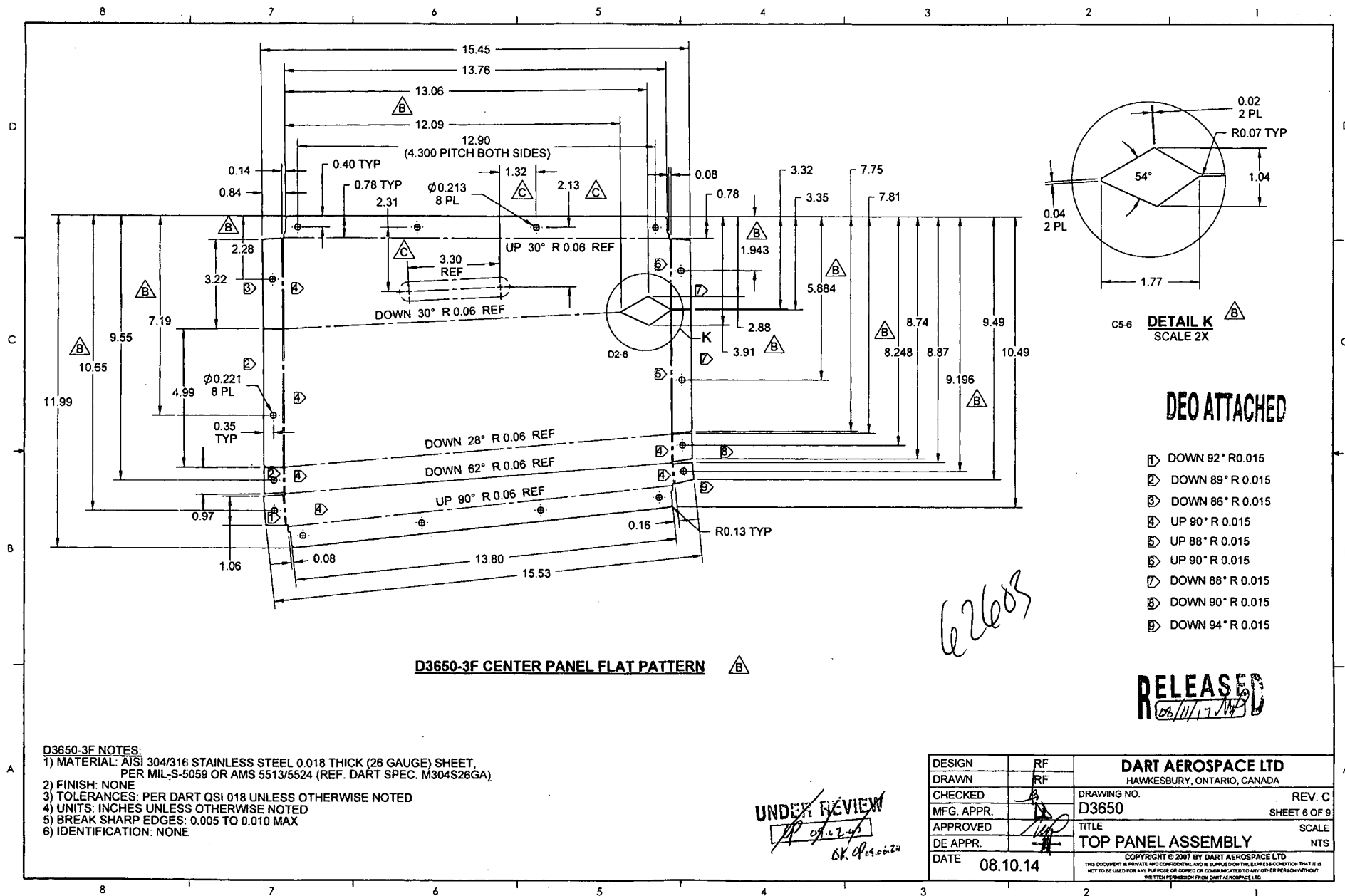
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3650</b>	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>TOP PANEL ASSEMBLY</b>	NTS
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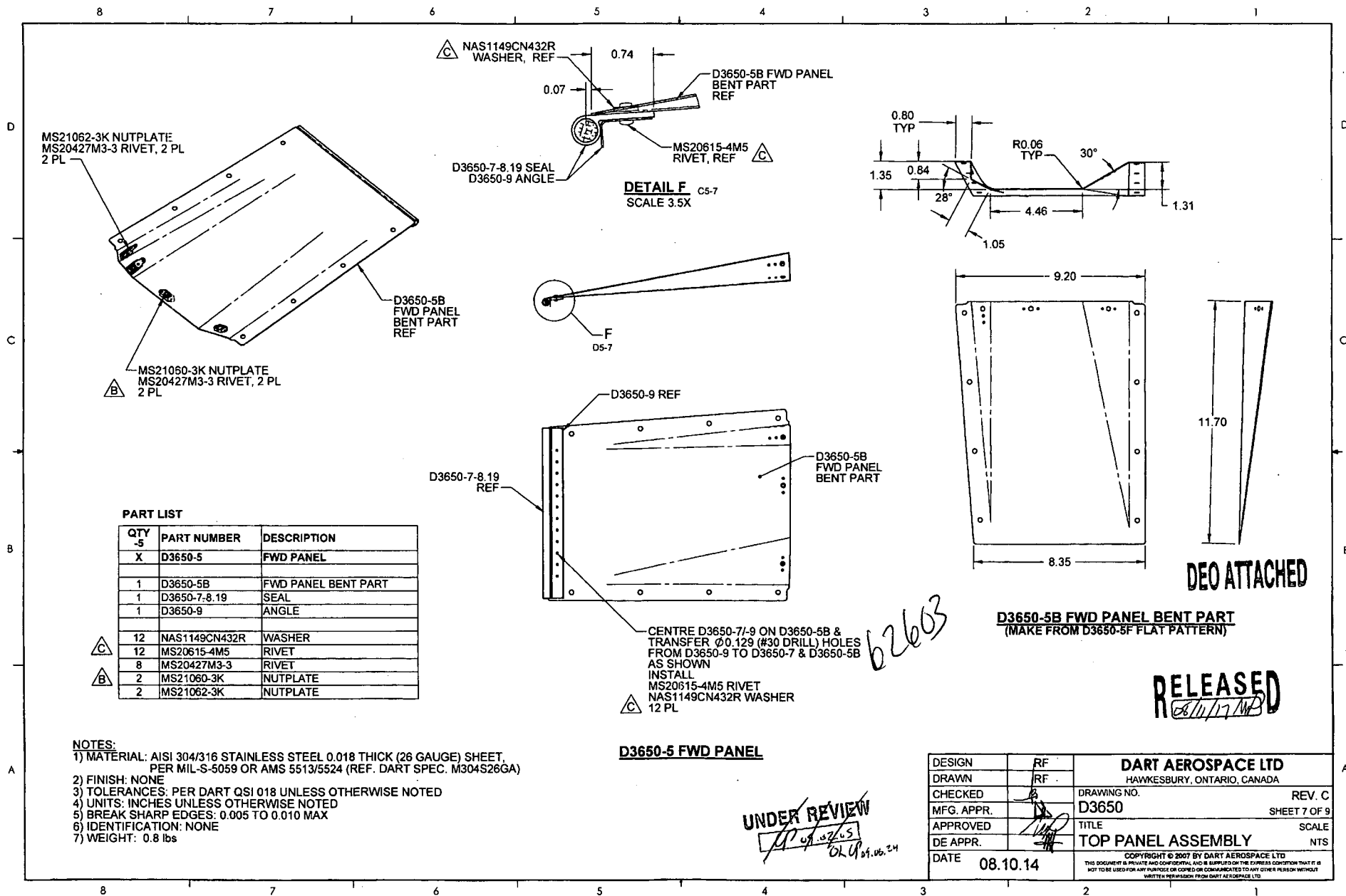
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**DEO ATTACHED**

**RELEASED**

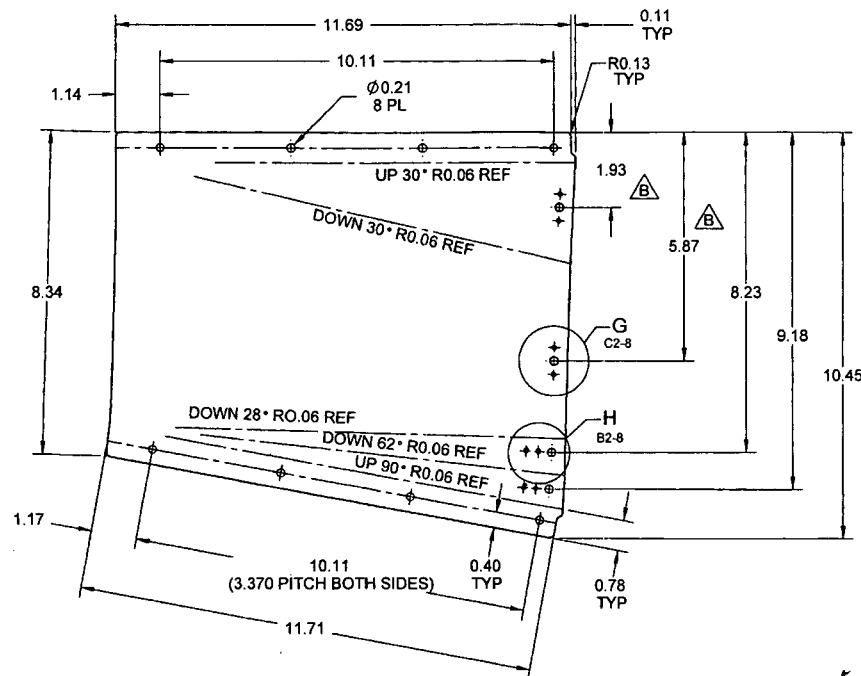




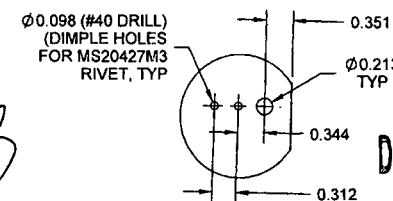
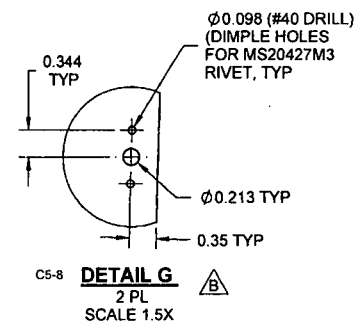
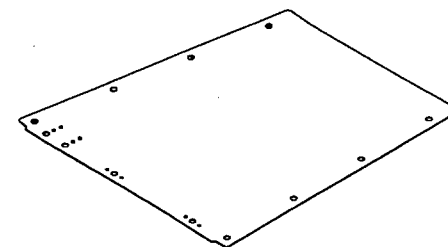








**D3650-5F FLAT PATTERN**



**DEO ATTACHED**

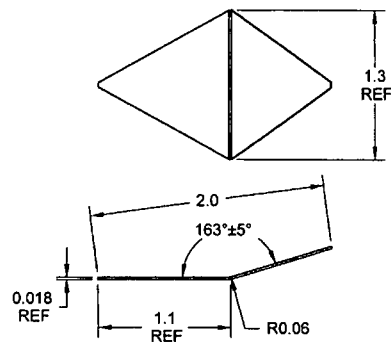
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08/11/17

**NOTES:**

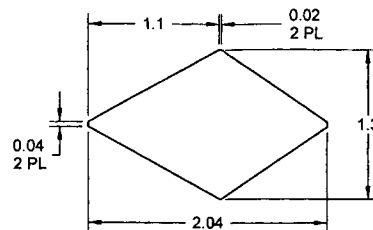
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

**UNDER REVIEW**  
10/10/14  
OK 10/14/14

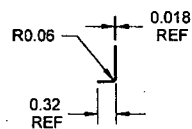
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3650</b>	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>TOP PANEL ASSEMBLY</b>	NTS
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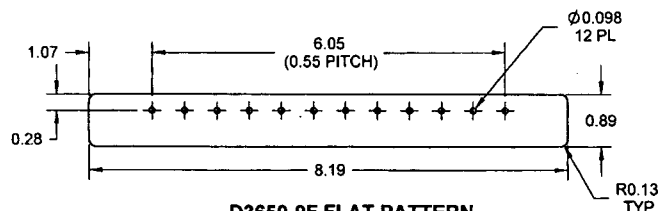
**D3650-11 FILLER PLATE**  
(MAKE FROM D3650-11F FLAT PATTERN)



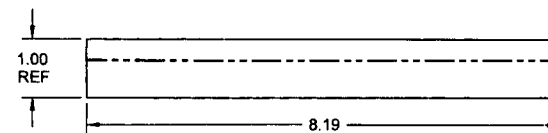
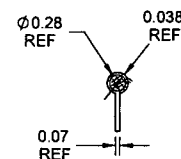
**D3650-11F FLAT PATTERN**



**D3650-9 ANGLE**  
(MAKE FROM D3650-9F FLAT PATTERN)



**D3650-9F FLAT PATTERN**



**D3650-7-8.19 SEAL**

**D3650-7-8.19 NOTES:**

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50




**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,  
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb  
D3650-11 WEIGHT: 0.007 lb

DEO ATTACHED

RELEASED  
03/11/17

UNDER REVIEW

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3650</b>	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>TOP PANEL ASSEMBLY</b>	NTS
DATE	<b>08.10.14</b>	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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DRAWING NO. D3650	TITLE TOP PANEL ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3650-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.06.12	DATE 04.06.15	DATE 09.06.15	DATE 09/06/15	DATE 09/06/15			

**TO AMEND D3650-5 FWD PANEL:**

REF PAR 09-008. THE QTY(12) NAS1149CN432R WASHERS ARE REPLACED WITH QTY(1) D3893-1 DOUBLER. THE QTY(12) MS20615-4M5 RIVETS ARE REPLACED WITH QTY(12) NAS9307M-4-03 RIVETS. LOCATION OF THE DOUBLER IS SHOWN IN THE AMENDED DETAIL F (DWG SHEET 7) BELOW. THE PARTS LIST FOR D3650-5 IS AMENDED AS FOLLOWS:

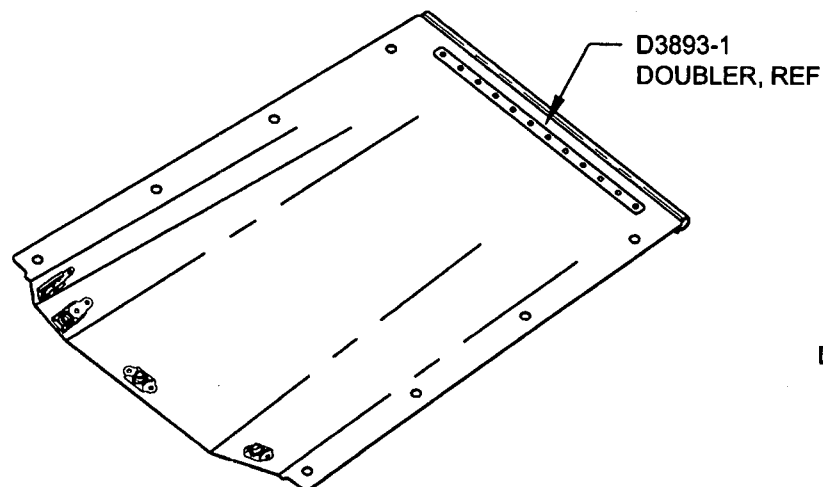
**IS:**

QTY	PART NUMBER	DESCRIPTION
-5		
1	D3893-1	DOUBLER
12	NAS9307M-4-03	RIVET (OR CR3523-4-03)

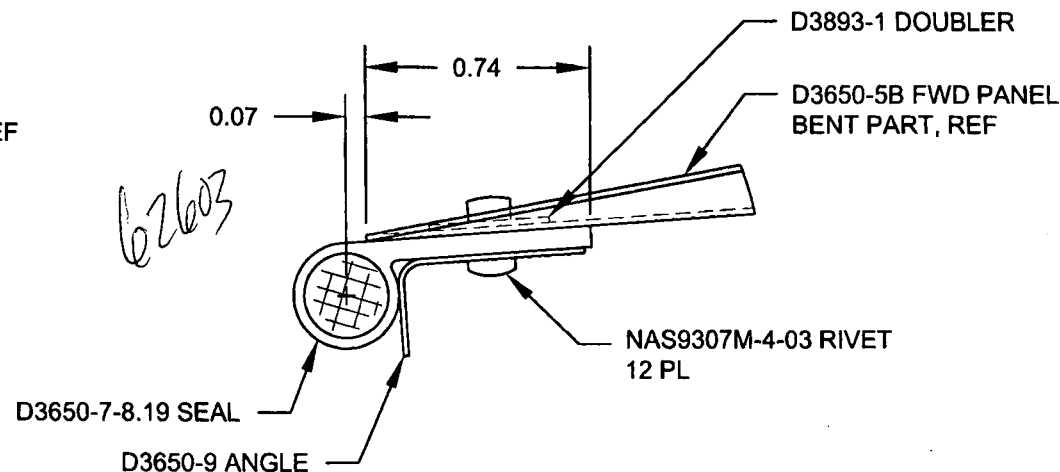
**WAS:**

QTY	PART NUMBER	DESCRIPTION
-5		
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET

**RELEASED**  
09/06/15



**D3650-5 FWD PANEL**



**DETAIL F** C5-7  
SCALE 3.5X

